

Al Hex 1.00

Work Order ID 69401

Tuesday, May 10, 2011 2:55:22 PM



Page 1

Item ID: D2806-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 5/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 5/10/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2806

Rev A

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA105 Rev: *HA* & Dwg D2806 Rev: *K* ☐ 2-Deburr
per dwg D2806

20 11-6-7

20

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

20 11-6-7

20

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5A 11/6/7

20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20, BK 11-6-9.

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20x 5/11/06/09

150

Identify as per dwg & Stock Location 20

0.00



Packaging

Memo

0.00

Packaging

11/06 SP 20

W/O:		WORK ORDER CHANGES						
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Revision ID:

Stop

Item Name: Bushing

Start Date: 5/10/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13
MF
11-06-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 10, 2011 2:55:28 PM

Page 1

Work Order ID: 69401



Parent Item: D2806-3



Parent Item Name: Bushing

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐ B ☐ 05.03.11 ☐ Part now turned ☐ KJ/JLM
IPP Rev:C Now on Doosan Lathe JLM Verified By:EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6H1.000

Purchased

No

110

f

16.4500

0.0916

1.928421



20 11.6.7

6061-T6 HexBar 1.00

Location

Loc Qty

Loc Code

MAT012

16.45

109478

4.45

116623

12

1.213

.303

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69401
Description: Bushing		Part Number:	D2806-3
Inspection Dwg: D2806 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.001	/		2R.02	
1.155	+/-0.010	1.140	/			STR MAT'L
0.250	+/-0.010	.253	/			
0.063 x 45°	+/-0.010	.066	/			
0.080 x 45°	+/-0.010	.075	/			
0.495	+0.000/-0.005	.493	/			
0.750	+0.000/-0.005	.748	/			
Ø0.316	+0.005/-0.000	.317	/			
0.094	+/-0.005	.091	/			

Measured by: [Signature]	Audited by: SA	Prototype Approval:	N/A
Date: 11.6.7	Date: 11/6/7	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	08.11.27	0.094 dimension added	KJ/EC [Signature]	[Signature]

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. *09401*

011-05-11

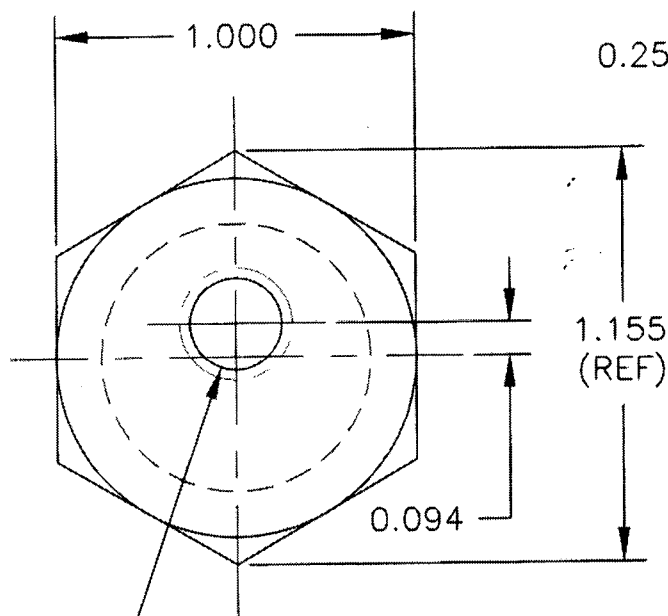
0.063 x 45°
CHAMFER

0.750^{+0.000}_{-0.005}

R0.010±0.005

0.080 *# 00.11.16*

0.050 X 45°
CHAMFER (TYP)



0.257 FOR D2806-1
0.316 FOR D2806-3

D2806-1 (DRILL 0.257 HOLE)
D2806-3 (DRILL 0.316 HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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